

**Claims**

1. An article of jewellery, in a body (2) of which an opening (4) is provided in which an element of ornamentation (5) is accommodated, in particular a precious stone or an ornamenting stone, wherein in said opening (4) of said body (2) of said article of jewellery (1) accommodating said element of ornamentation (5) a support (7) for said element of ornamentation (5) is formed by which the depth of insertion of said element of ornamentation (5) in said opening (4) of said body (2) of said article of jewellery (1) is defined and by which a lower edge (5') of said element of ornamentation (5) is supported at least selectively, wherein said article of jewellery (1) comprises a securing element (10) extending at least along a part of the circumference of said opening (4), characterised in that said securing element (10) is formed by reaming said opening (4) of said body (2) of said article of jewellery (1) in an area (11) surrounding said opening (4) and subsequently stabilizing the material which was eroded from said area (11) surrounding said opening (4) of said body (2), that said securing element (10) acts upon an upper edge (5'') of said element of ornamentation (5) at least selectively, and that said area (11) surrounding said opening (4) of said body (2) of said piece of jewellery (1) is at least partially bevelled.
2. The article of jewellery according to claim 1, characterised in that said securing element (10) is formed extending substantially along the whole circumference of said opening (4).
3. The article of jewellery according to claim 1, characterised in that said opening (4) comprises an upper portion (4'), which has a diameter (d') which is larger than a diameter (D) of said element of ornamentation (5), and a lower portion (4'') with a diameter (d) which is smaller than said diameter (D) of said element of ornamentation (5).

4. The article of jewellery according to one of the previous claims, characterised in that between said upper portion (4') and said lower portion (4'') of said opening (4) a transition portion (6) is formed which constitutes said support (7) for said element of ornamentation (5).
5. The article of jewellery according to one of the previous claims, characterised in that in said opening (4) a means (8) for protection against twisting of said element of ornamentation (5) is provided.
6. The article of jewellery according to one of the previous claims, characterised in that said article of jewellery is formed as a ring (1'), a pendant, a part of a link of a chain, as jewellery for ears, as part of a clock or a watch, or of a watchband.
7. A method for manufacturing an article of jewellery (1), especially a ring (1'), in the body (2) of which an opening (4) is provided in which an element of ornamentation (5) is accommodated, in particular a precious stone or an ornamenting stone, wherein said opening (4) provided in said body (2) of said piece of jewellery (1) after a first step of said method has a diameter (d) which is smaller than said diameter (D) of said element of ornamentation (5) to be inserted into said opening (4), wherein in a subsequent step an upper portion (4') of said opening (4) is formed with a diameter (d') which is equal to or larger than said diameter (D) of said element of ornamentation (5), such that between said upper portion (4') of said opening (4) with said diameter (d') and a lower portion (4'') of said opening (4) with said smaller diameter (d) a transition portion (6), serving as a support (7) for said element of ornamentation (5) is formed, that said element of ornamentation (5) is inserted into said opening (4) and set onto said support (7), whereby in a subsequent step the material of said body (2) of said article of jewellery (1) is eroded in an area (11) surrounding said opening (4) and that said eroded material is brought to said element of ornamentation (5) accommodated in said opening (4) of said body (2), characterised in that the erosion of material in said area (11) of said opening (4) is executed by reaming said area (11) surrounding said opening

(4), that a securing element (10) for said element of ornamentation (5) is formed from the such eroded and later restabilized material such that an upper edge (5'') of said element of ornamentation (5) is acted upon at least selectively by said such formed securing element (10), and thus said element of ornamentation (5) is fixed in position in said opening (4), and that said area (11) surrounding said opening (4) is bevelled at least partially by this reaming.

8. The method according to claim 7, characterised in that said securing element (10) is formed extending substantially the whole circumference of said opening (4).
9. The method according to claim 8, characterised in that a means (8) for protection against twisting of said element of ornamentation (5) is provided in said support (7).
10. A tool for the implementation of the method according to one of claims 8 to 9, characterised in that said tool (W) comprises a tool body (W1) having an interior (W2), in which said element of ornamentation (5) may be accommodated and that said tool (W) comprises a reaming area (W5) at its front face (W').
11. The tool according to claim 10, characterised in that said reaming area (W5) is divided into a plurality of segments (W3).
12. The tool according to claim 10, characterised in that said reaming area (W5) is formed extending inclined to said outer surface of the tool body (W1).
13. The tool according to one of claims 10 to 12, characterised in that said tool body (W1) of said tool (W) is disposed at a shank (W6).